

Work Order ID 86830

86830

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July-06-12 3:02:30 PM

Item ID: D2587 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Door Slug, 350 Hinge
 Start Date: 7/06/12 Start Qty: 20.00 ***20*** Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 20.00 ***20*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: 12079 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2587	Rev A1								

100 FLOW WATER JET 0.00
100
 Waterjet Memo 0.00 20 0 Jm 12-7-22
 FLOW CNC Waterjet 1-Cut as per Dwg D2587 Dwg Rev: A1 Prog Rev: A1 2-
 Deburr if necessary
6061. 046

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00 20 0 Jm 12-7-22
 Quality Control

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00 20 0 Jm 12-7-22
 Quality Control

SMB
12-7-23
DA 10
9-05
12/6/23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Dart Aerospace Ltd

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Work Order ID 86830***86830***

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July-06-12 3:02:30 PM

Item ID: D2587

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Door Slug, 350 Hinge

Start Date: 7/06/12 Start Qty: 20.00

20

Cust Item ID:

Required Date: 8/03/12 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MF
12-07-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 86830

Parent Item: D2587

Parent Item Name: Door Slug, 350 Hinge

Start Date: 7/06/12

Required Date: 8/03/12

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP D04.05.31 Step 2 changed KJ/JLM
IPP E06.07.31 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.040
6061-T6 .040 Sheet

Purchased

No

100

sf

253.2578

0.016

~~0.336842~~

0.4

Jm 12.7.22

Location

Loc Qty

Loc Code

MAT021

253.2578

121030

12.9178

121099

240.34

121099

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Dart Aerospace Ltd

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

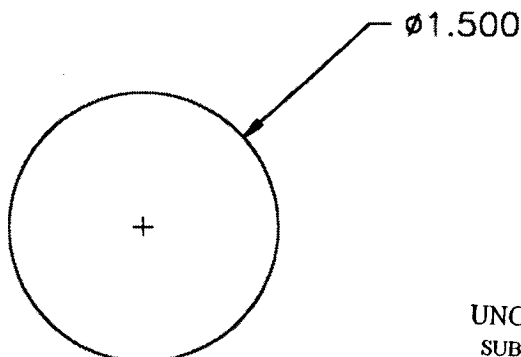
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DESIGN MIKE M	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED M. M.	APPROVED M. M.	DRAWING NO. D2587	REV. A SHEET 1 OF 1
DATE 96:07:11		TITLE DOOR SLUG	SCALE 1:1
AI KJ 03.09.16		ADD 6061-T6 OPTION	

RELEASED
9607/23 B.U.



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84830

012-079

OR 6061-T6 (QQ-A-200/B OR QQ-A-225/B)

MATERIAL: 5052-H32, 0.040 THICK
FINISH: ACID ECTCH, ALODINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Insp.

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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